

5/46

SPLIT

DART AEROSPACE LTD	Work Order:	24315 A
Description: Skidtube Material	Part Number:	D6014-064 ^{104 90}
Dwg: D6014 Rev. A	Qty:	36 10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>[Signature]</i>	05.10.03	36
2	PG	Issue P/O: <u>2008621</u> a) Extrude as per Dwg D6014 b) Material: 7075-T73/T73510/T73511 (QQ-A-200/11) Seamless Aluminum Tube c) Minimum ultimate tensile strength = 68 ksi d) Minimum tensile yield strength = 57 ksi Possible Supplier: Aluminum Works Material certification is required <i>419.2468</i>	<i>U</i>	05.09.12	36
3	RG	Receive and Inspect for transit damage Ensure Material certification is attached	<i>CL</i>	05/11/08	10
4	QC6	Inspect dimensions as per Dwg D6014 Ensure Material certification complies with Dwg D6014	<i>[Signature]</i>	05.11.08	10
5	FP	Chemical Conversion Coat as per QSI 005 4.1			
6	QC3	Inspect Chemical Conversion Coat			
7	ST	Identify and Stock	<i>CL</i>	05/11/09	10
8	AC	Cost / part: <u>419.25</u>	<i>Sar</i>	05.11.10	10
9	DC	Close W/O <u>419.25</u> Inspect Level 21	<i>[Signature]</i>	05/11/10	10

Rev	Date	Change	Revised By	Approved
A	05.08.31	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
1/15/09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 19 Date: 05/11/16

NOTE: Date & initial all entries

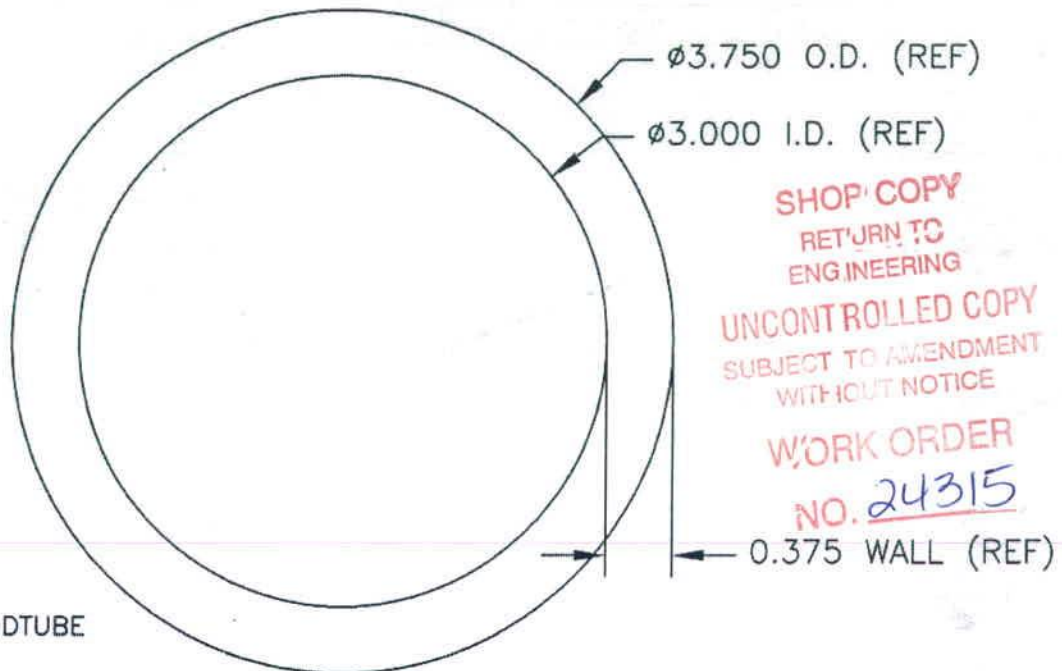
QA: N/C Closed: _____ Date: _____

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6014	REV. A SHEET 1 OF 1
DATE 05.03.18	TITLE SKIDTUBE MATERIAL		SCALE 1:1
A	05.03.18	NEW ISSUE	

RELEASED
05-08-09 *[Signature]*

SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24315

NOTES

- 1) D6014-XXX SKIDTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 64" LONG TUBE: D6014-064

- 2) MATERIAL: 3.750 OD x 0.375 WALL 7075-T73/T73510/T73511 PER QQ-A-200/11
SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 68 ksi
MINIMUM YIELD TENSILE STRENGTH = 57 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
WALL: ± 0.015 MEAN (± 0.038 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.188/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 20, 2005
09:59 am

Work Order No : 0024315
Project Name : D6014-104
Project For : WK546
Work Order Type : Main
Main WO Number :
House Part Number : D6014-104
Description :
Manufactured : No
Amount Req'd : 0
Amount Done : 0
Start Date : 09-20-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



ALUnna

Abnahmeprüfzeugnis 3.1 - EN 10204:2004**Inspection Certificate 3.1 - EN 10204:2004 / Certificat de Reception 3.1- EN 10204:2004****Kunde:** Dart Aerospace Ltd.
Client:1270 Aberdeen Street
K6A1K7 Hawkesbury, ON Canada**Zeugnisnummer:** 837/05

Cert No.: / No. du certificat:

Bestellnummer: 2008621

Order No. / No. de commande

Auftrag: 15626/1

Our Reference/Notre Reference:

Produkt:

Product / Produit:

Rohre nahtlos gepresst
Tubes seamless extruded Tubes file sur aiguille**Spezifikation:**

Specification:

AMS - QQ - A - 200/11E

Werkstoff:

Alloy/Alliage:

7075

Zustand:

Temper/État

T 73511

Abmessung

Size / Dimension

3,750 INCH x 3,000 INCH x 0,375 INCH x 104,000 INCH

D6014-104

Kennzeichnung

Marking/Marquage:

ALUnna-Cert No.837/05-7075-T73511-cast No.4692-AMS-QQA/200/11E-3.750" OD X0.375"Wall-Heat No.250/10-
lot15626/1-1-P.O.2008621**Lieferung**

Delivered Material / Matériel délivré:

pcs.

lbs

10

428

1. Chemische Analyse**Chemical Analysis / analyse chimique**

Charge/	min.	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Zr	Bi	Sn	Ni
Cast No.	max.	0,40	0,50	2,0	0,30	2,9	0,28	6,1	0,20					
4692/05		0,077	0,174	1,445	0,032	2,415	0,210	5,898	0,039	0,003	0,0344	0,0001	0,0013	0,0040

Elements without indication < 0,01 %

2. Mechanische Eigenschaften**Mechanical Properties / Valeurs Mécaniques**

Anforderungen	tensile	yield	elongation	elongation	Hardness	Heat No.
Requirements	(Rm) ksi	(Rp0,2) ksi	2" %	A %	HB	
min.	68,0	57,0				
max.						
1	80,330	71,775	11,0		151	250/10 - 10 pcs.

Ergebnis der Prüfungen:

Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

Test results:

We confirm that the delivery has been tested and applies to the agreements made on receipt of the order

Resultats:

Nous confirmons que la livraison a été contrôlée et correspond avec les conventions faites à la réception de la commande

KroosD

Certified acc. to DIN EN ISO 9001:2000, valid until 2006-03-09
Certificate No.: 001959 QM

ALUnna

Abnahmebeauftragter

31.10.2005

